

Work Order ID 152906

Monday, November 07, 2016 4:06:22 PM

152906

Page 1

Item ID: D3699-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Assembly

Start Date: 10/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

DAS**21**

Date: NOV 09 2016 Tooling:

Date:

Run Start ***NR1***

QC:

9-59

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3699	Rev A								

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3699

Dwg Rev: **A**Prog Rev: **A**

***grain direction along 9.00" ***

2- Deburr if necessary

(2)

Dec 16/11/19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(2)

Dec 16/11/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																													
Description Work Order Deviation				Disposition																																																																															
<table style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> <th colspan="4" style="text-align: left; padding: 5px;">FAULT CATEGORY</th> </tr> <tr> <td style="width:15%; padding: 5px;">Environment ☐</td> <td style="width:15%; padding: 5px;">☐ No Re-verification</td> <td style="width:15%; padding: 5px;">Pressure/Forced ☐</td> <td style="width:15%; padding: 5px;">Temperature/Cure ☐</td> <td style="width:15%; padding: 5px;">Power Loss/Surge ☐</td> <td style="width:15%; padding: 5px;">Positioned Wrong ☐</td> </tr> <tr> <td style="padding: 5px;">Design ☐</td> <td style="padding: 5px;">☐ Operator</td> <td style="padding: 5px;">Bending ☐</td> <td style="padding: 5px;">Set-up ☐</td> <td style="padding: 5px;">Folio/Program ☐</td> <td style="padding: 5px;">Outside Dimensions ☐</td> </tr> <tr> <td style="padding: 5px;">Doc/Data ☐</td> <td style="padding: 5px;">☐ Offset/Setup</td> <td style="padding: 5px;">Centre Not Concentric ☐</td> <td style="padding: 5px;">BOM/Route ☐</td> <td style="padding: 5px;">Grain ☐</td> <td style="padding: 5px;">Over/Under tolerance ☐</td> </tr> <tr> <td style="padding: 5px;">Equip/Tooling ☐</td> <td style="padding: 5px;">☐ Supplier</td> <td style="padding: 5px;">Cracks ☐</td> <td style="padding: 5px;">Broken/Damage/Defect ☐</td> <td style="padding: 5px;">Weld ☐</td> <td style="padding: 5px;">Part Incorrect ☐</td> </tr> <tr> <td style="padding: 5px;">Handling/Pre ☐</td> <td style="padding: 5px;">☐ Training</td> <td style="padding: 5px;">Crimp/Kink/Ripple/Wave ☐</td> <td style="padding: 5px;">Inspection Incomplete/Unqualified ☐</td> <td style="padding: 5px;">Wrong Stock Pulled ☐</td> <td style="padding: 5px;">Part Lost/Missing ☐</td> </tr> <tr> <td style="padding: 5px;">Material ☐</td> <td style="padding: 5px;">☐ Use for Testing</td> <td style="padding: 5px;">Cuffs ☐</td> <td style="padding: 5px;">Contamination ☐</td> <td style="padding: 5px;">Out of Sequence ☐</td> <td style="padding: 5px;">Part Moved ☐</td> </tr> <tr> <td style="padding: 5px;">Internal Transport ☐</td> <td style="padding: 5px;">☐ Poor Information</td> <td style="padding: 5px;">Crushing ☐</td> <td style="padding: 5px;">Countersink ☐</td> <td style="padding: 5px;">Off-set ☐</td> <td style="padding: 5px;">Drawing ☐</td> </tr> <tr> <td style="padding: 5px;">Tribal Knowledge ☐</td> <td style="padding: 5px;">☐ Rushing</td> <td style="padding: 5px;">Heat Treat ☐</td> <td style="padding: 5px;">Cut Too Short ☐</td> <td style="padding: 5px;">Mislabeled ☐</td> <td style="padding: 5px;">Finish ☐</td> </tr> <tr> <td style="padding: 5px;">LOA ☐</td> <td style="padding: 5px;">☐ Product Improvement</td> <td style="padding: 5px;">Wave/Twist in Tube ☐</td> <td style="padding: 5px;">Instructions Incomplete/Unclear ☐</td> <td style="padding: 5px;">Fit/Function ☐</td> <td style="padding: 5px;">Misread ☐</td> </tr> <tr> <td style="padding: 5px;">Substation ☐</td> <td style="padding: 5px;">☐ Process Improvement</td> <td style="padding: 5px;">Marks/Chatter ☐</td> <td style="padding: 5px;">Drill Holes ☐</td> <td style="padding: 5px;">Misaligned/off center ☐</td> <td style="padding: 5px;">Turning Sequence ☐</td> </tr> <tr> <td style="padding: 5px;">Past Expiry Date ☐</td> <td style="padding: 5px;">☐ Manufacturing Process</td> <td colspan="4" rowspan="2" style="padding: 5px; vertical-align: top;"> OTHER : _____ </td> </tr> <tr> <td style="padding: 5px;">Misidentified ☐</td> <td style="padding: 5px;">☐ Past Due</td> </tr> </table>								Root Cause				FAULT CATEGORY				Environment ☐	☐ No Re-verification	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				Misidentified ☐	☐ Past Due
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Work Order ID 152906***152906***

Page 2

Item ID: D3699-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support Assembly

Stop

NS2

Start Date: 10/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
30
3-89

2

DAS
38
3-89
NOV 21 2016

130

Bend as per dwg

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

DAS
30
3-89

2

NOV 21 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

2

DAS
38
3-89
NOV 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
QC / QA Coordinator Approval																					
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Work Order ID 152906

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152906

Page 3

Item ID: D3699-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support Assembly

Stop ***NS2***

Start Date: 10/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

150

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3699

2x _____ 16/11/23
DAS 36 9-89

160

160

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

2 _____
DAS 38 9-89
NOV 23 2016

170

170

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

(x2) _____ 2016/11/23
BEB.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 152906

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152906

Page 4

Item ID: D3699-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support Assembly
Start Date: 10/26/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 129 777</i> Memo START TIME: <i>11:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:50</i>	0.00 0.00				<i>2</i>	<i>0</i>	<i>16-11-23</i>	<i>DAS 34 9-89</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>2</i>			<i>DAS 38 1-89</i>
NOV 23 2016									
200 *200* Packaging Packaging	Pick Kit Memo	0.00 0.00				<i>2x</i>		<i>16/11/23</i>	<i>DAS 36 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Work Order ID 152906

Monday, November 07, 2016 4:06:22 PM

152906

Page 6

Item ID: D3699-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support Assembly
Start Date: 10/26/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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			OTHER : _____																																																																		

Picklist Print

Monday, November 07, 2016 4:06:21 PM

Page 1

Work Order ID: 152906

152906

Parent Item: D3699-041

D3699-041

Parent Item Name: Support Assembly

Start Date: 10/26/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:ec
IPP Rev:B 08-07-14 revA as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		210	sf	58.5200	0.4569	0.961895			

M6061T6S 050

6061-T6 .050 Sheet

**

16/11/19

Location

Loc Qty

Loc Code

MAT021

58.52

m131352

58.52

MS20426AD3-3

Purchased

No

100

Each

5,832.000

2

4

MS20426AD3-3

RIVET

**

16/11/23 DAS 36 9-89

Location

Loc Qty

Loc Code

fg108

480

M134946

200

M135354

120

M135894

160

GA

2384

M135274

2384

ST312

2968

M135274

2968

MS21059L3

Purchased

No

210

Each

99.0000

1

2

MS21059L3

Nut Plate

**

16/11/23 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

29

M135603

29

ST301

70

M135704

10

M135774

60

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

DART AEROSPACE LTD		Work Order: 152906
Description: Support, LH		Part Number: D3699-1
Inspection Dwg: D3699 Rev: A		Page 1 of 1

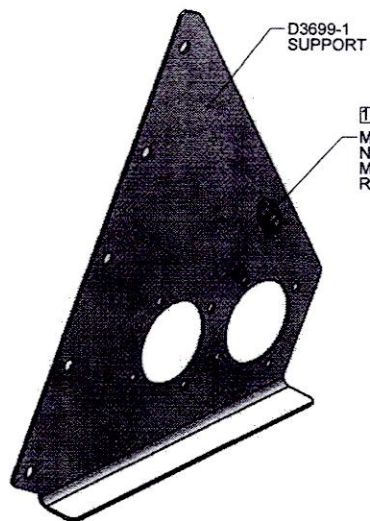
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

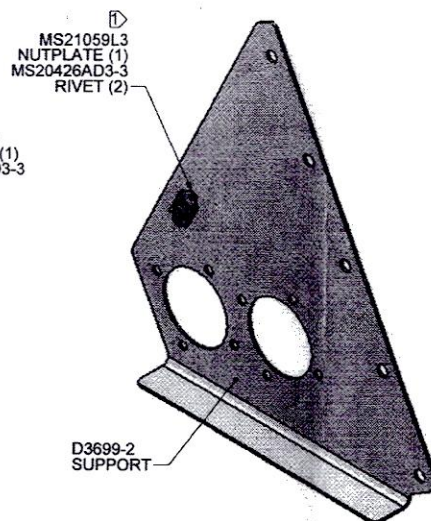
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.099	/		Viper-01	
Ø0.180	+0.005/-0.001	Ø.179	/		Tape	
Ø0.238	+0.005/-0.001	Ø.237	/			
Ø1.525	+0.012/-0.001	Ø1.524	/			
0.36	+/-0.030	.363	/			
0.62	+/-0.030	.62	/			
0.96	+/-0.030	.96	/			
2.21	+/-0.030	2.21	/			
4.12	+/-0.030	4.12	/			
8.95	+/-0.030	8.95	/			
1.925	+/-0.010	1.923	/			
8.61	+/-0.030	8.61	/			
2.62	+/-0.030	2.62	/			
0.344	+/-0.010	.343	/			
0.688	+/-0.010	.689	/			
0.64	+/-0.030	.64	/			
2.66	+/-0.030	2.66	/			
5.75	+/-0.030	5.75	/			
6.41	+/-0.030	6.41	/			
0.300	+/-0.010	.300	/			
0.923	+/-0.010	.923	/			
0.050	+/-0.010	.049	/			

Measured by: DC	Audited by: 38	Prototype Approval:	N/A
Date: 11/11/19	Date: NOV 21 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	



D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

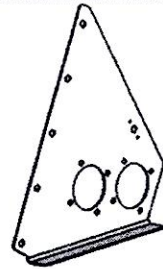
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152906 MJS
16-11-09

RELEASED
08.07.09

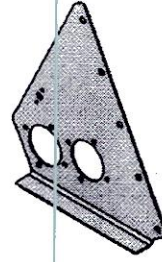
NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\phi 0.098$ HOLES ON D3699-1/-2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699 041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

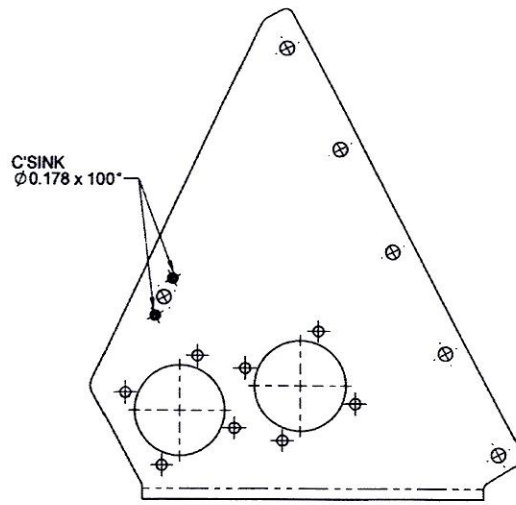
A	NEW ISSUE		RF	08.05.12
REV.	DESCRIPTION		BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A	
DRAWN	JP		SHEET 1 OF 2	
CHECKED	JP		SCALE	
MFG. APPR.	JP		NTS	
APPROVED	JP		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DE APPR.	JP		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.05.12	SUPPORT ASSEMBLY		



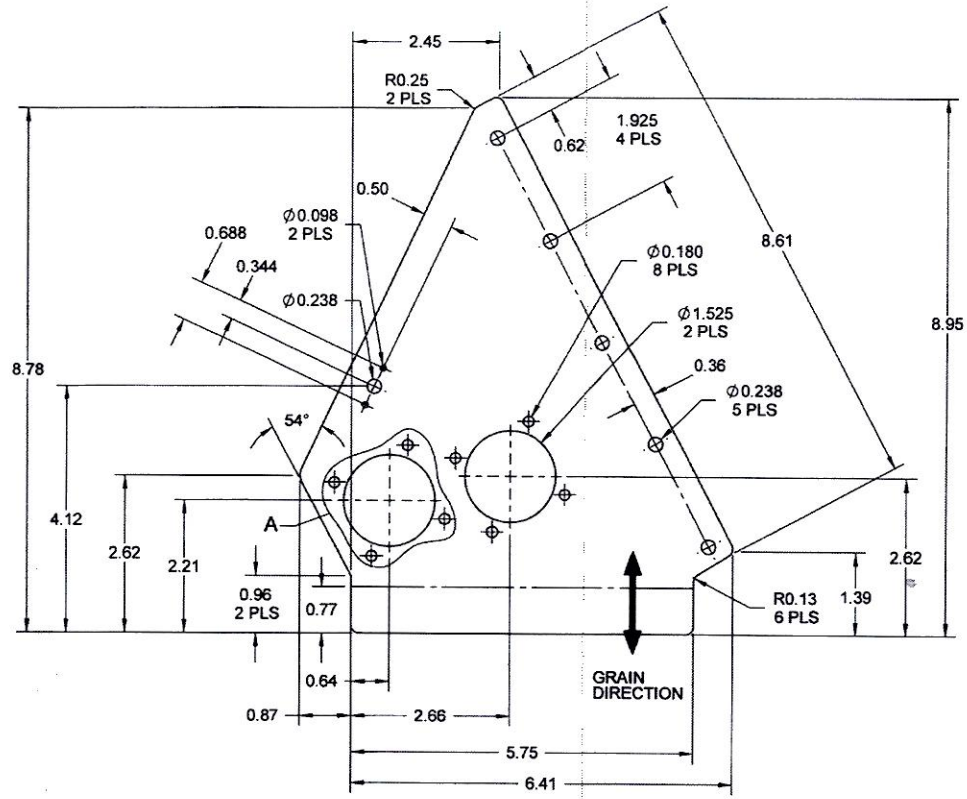
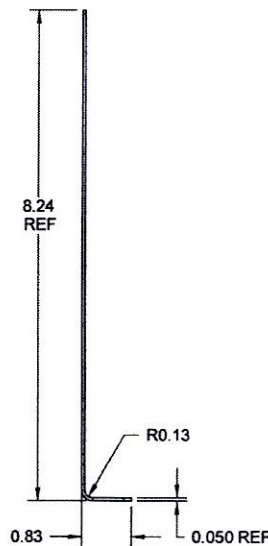
D3699-1 LH SUPPORT



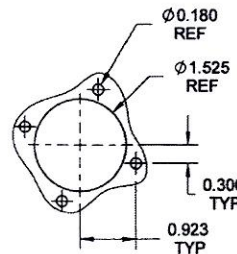
D3699-2 RH SUPPORT



**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**



D3699-1F FLAT PATTERN



DETAIL A

RELEASED
08-07-08

- NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
DATE	08.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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